

Date: Tuesday, 28/04/2009 12:38:21 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
<b>Job Number</b> :	47565	<b>Part Number</b> :	D2572	
<b>Estimate Number</b> :	10531	<b>Drawing Number</b> :	D2572 REV E	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	28/04/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	E	
<b>First Issue</b> :	/ /	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :	47248	<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	07/05/2009	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>JUD 09.04.28</u>			
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2572  
 Ensure that grain is along 5.00" length  
 Batch No: 46411

JL 09/05/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 47565 Double check by: JDA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove shap edges.

JL / Y.A 09/05/09

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

JL / Y.A 09/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 28/04/2009 12:38:21 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 47565

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/05/09

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

STP 09/05/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/05/11

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:05

OVEN TEMPERATURE:

320°

FINISH TIME:

9:35

FL 09/05/12

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-05-12

(XV)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 433

AS 09/05/12

(V&)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13

Job Completion



MF 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47565
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.434	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		.500	0.499	0.500	0.497		
G	0.257	0.262		.259	0.259	0.259	0.259		
H	0.375	0.380		.376	0.376	0.376	0.376		
I	0.490	0.510		.500	0.501	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	0.127	0.128	0.127		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.251	0.250	0.250		
S	0.115	0.135		.124	0.124	0.126	0.125		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	0.240	0.239	0.239		
W	0.115	0.135		.116	0.124	0.124	0.123		
X	0.307	0.312		.310	.310	0.310	0.310		
Y	0.760	0.765		.760	.760	0.760	0.760		
Z	0.352	0.372		.352	0.360	0.362	0.362		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.625	0.628	0.628	0.628		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.247	0.244	0.244	0.244		
AE	1.375	1.395		1.388	1.3912	1.3916	1.3917		
AF	0.115	0.135		.135	0.135	0.135	0.135		
AG	0.240	0.280		.260	0.257	0.257	0.257		
AH	0.240	0.260		.249	0.248	0.246	0.246		
AI	2.000	2.020		2.003	2.010	2.010	2.011		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SL / H.A
Date:	09/05/08 / 09/05/09

Audited by:	DTJ
Date:	09/05/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 47565
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

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C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
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H	0.375	0.380		0.376	0.376	0.376	0.376		
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J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
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P	0.115	0.135		0.127	0.128	0.127	0.127		
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T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.238	0.237	0.237		
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X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.361	0.361		
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AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.244	0.244	0.244		
AE	1.375	1.395		1.3907	1.3915	1.391	1.391		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.257	0.257	0.257	0.257		
AH	0.240	0.260		0.245	0.244	0.245	0.245		
AI	2.000	2.020		2.012	2.018	2.011	2.012		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: H.A
Date: 09/05/09

Audited by: JJP
Date: 09/05/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

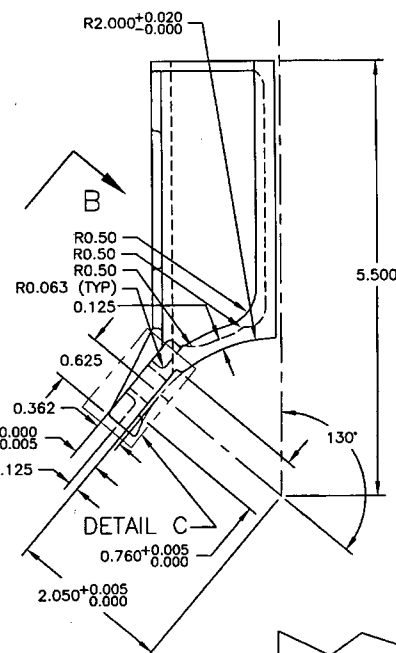
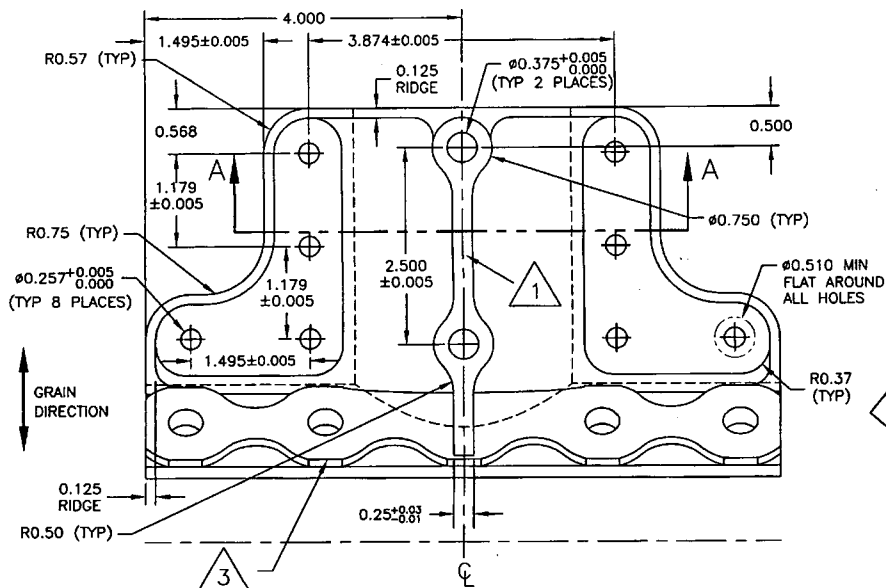
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries








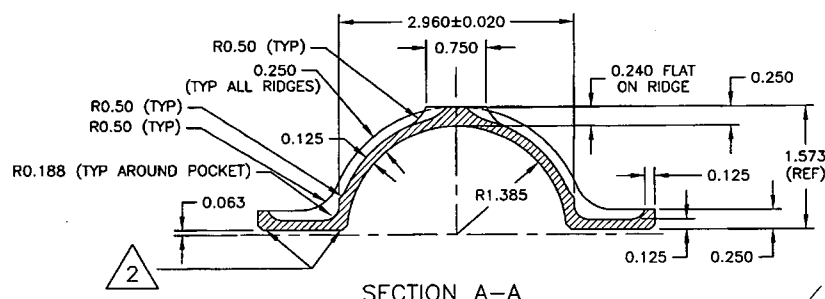
05.12.06



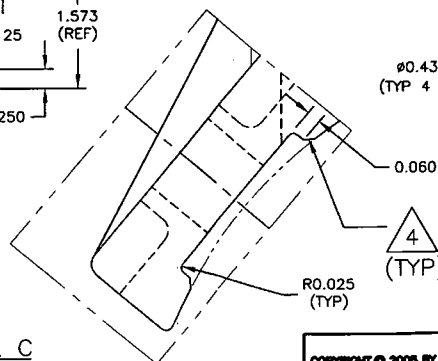
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

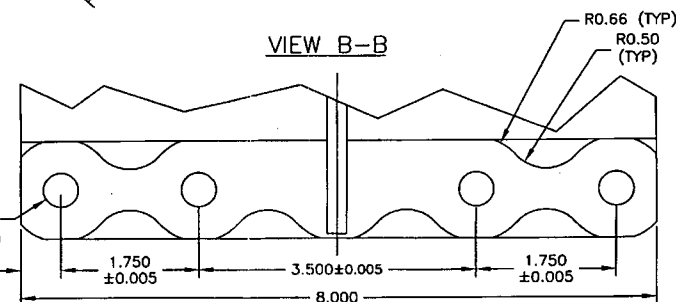
- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |
-  E






SECTION A-A



DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		<b>DART AEROSPACE LTD.</b> HARRISBURG, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE
		REV. 1 OF 2 SHEET 1 OF 2 SCALE

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4555

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part.No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries